

Duplicate

82838

June-11-12 7:09:32 AM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 4/10/12 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 4/20/12 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date: _____

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

[illegible]

82838

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N900040100

Setup Start *NS1*

Stop *NS2*

10

Cust Item ID:

10

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

**Insp.
Stamp**

0.00

130

HandFinish

Memo

0.00

Hand Finishing

140

0.00

140

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE: _____

FINISH TIME:

0.00

150

0.00

150

QC

Quality Control

Memo

0.00

82838

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N900040100

Setup Start *NS1*

Stop *NS2*

10

10

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

160

0.00

160

Small Fab

0.00

Small Fab

Small Fab

Memo

Assemble as per Dwg D3290
Clean D3290-041 and place in plastic wrap

0.00

170

170

QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

180

180

Identify as per dwg & Stock Location 2/1

0.00

Packaging

Packaging

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: <u>82838</u> Part No. <u>D3290-041</u> NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<table style="width:100%;"> <tr> <td style="width:15%;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </td> <td style="width:15%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </td> <td style="width:15%;"> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Other <input type="checkbox"/> </td> <td style="width:15%;"> Engineering Quality <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> </td> </tr> </table>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Other <input type="checkbox"/>	Engineering Quality <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>
Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Other <input type="checkbox"/>	Engineering Quality <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>	20613	160	4	Restock frames above D3290-1 B82838	[Signature] 20613				
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Offset/Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unauthorized <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear	Hardware	General	Maintenance
<input type="checkbox"/> Bending Passes Below Min	<input type="checkbox"/> Breaking	<input type="checkbox"/> Burrs	<input type="checkbox"/> Set-up
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> Missing	<input type="checkbox"/> Contamination	<input type="checkbox"/> Supplier
<input type="checkbox"/> Cracks	<input type="checkbox"/> Size/Length	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Crushed/Crimp at Bending	<input type="checkbox"/> Spinning	<input type="checkbox"/> Documentation/Data	<input type="checkbox"/> Orientation Misread
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Threading	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Other	<input type="checkbox"/> Wrong	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Positioned Wrong		<input type="checkbox"/> Inspection Unqualified	<input type="checkbox"/> Outside Dimensions
<input type="checkbox"/> Ripples on Inner Bend	Drill Holes	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Over/Under tolerance
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Misaligned	<input type="checkbox"/> Jigs/Fixtures/Tooling	<input type="checkbox"/> Part Lost
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Kit Incorrect	<input type="checkbox"/> Part Moved
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Over/Undersized	<input type="checkbox"/> Kit Missing	<input type="checkbox"/> Raw Material
	<input type="checkbox"/> Too Many		<input type="checkbox"/> Wrong Stock Pulled
			<input type="checkbox"/> Other

Work Order ID 82838***82838***

Page 4

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Item ID: D3290-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Replacement Window Assembly
Start Date: 4/10/12 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 4/20/12 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

12/6/14 *[Signature]*
MF
1206-13

Picklist Print

June-11-12 7:09:31 AM

Page 1

Work Order ID: 82838

Parent Item: D3290-041

Parent Item Name: Replacement Window Assembly

Start Date: 4/10/12

Required Date: 4/20/12

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP B05.05.25 Added Step 11KJ/JLM
IPP C06.05.09 Ecn 798 EC
IPP Rev:D Now on Waterjet 06-06-16 JLM
IPP rev E rev C dwg 07.09.28 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No			100	sf	604.8822	3.75	<u>39.473684</u>			

Location	Loc Qty	Loc Code
MAT021	604.8822000	
113608	0	
116308	6.01556842	
117285	67.544	
119331	44.2	
119802	15.94	
120218	19.34	
120866	66.6026316	
121805	385.24	

D2126 Seal
(D2126-0780) cut qty (1) at 78.00" as per dwg ***per kit***

Manufactured No

Location	Loc Qty	Loc Code
ST405	320.93029	
57106	4	
68336	2.44679	
76094	314.4835	

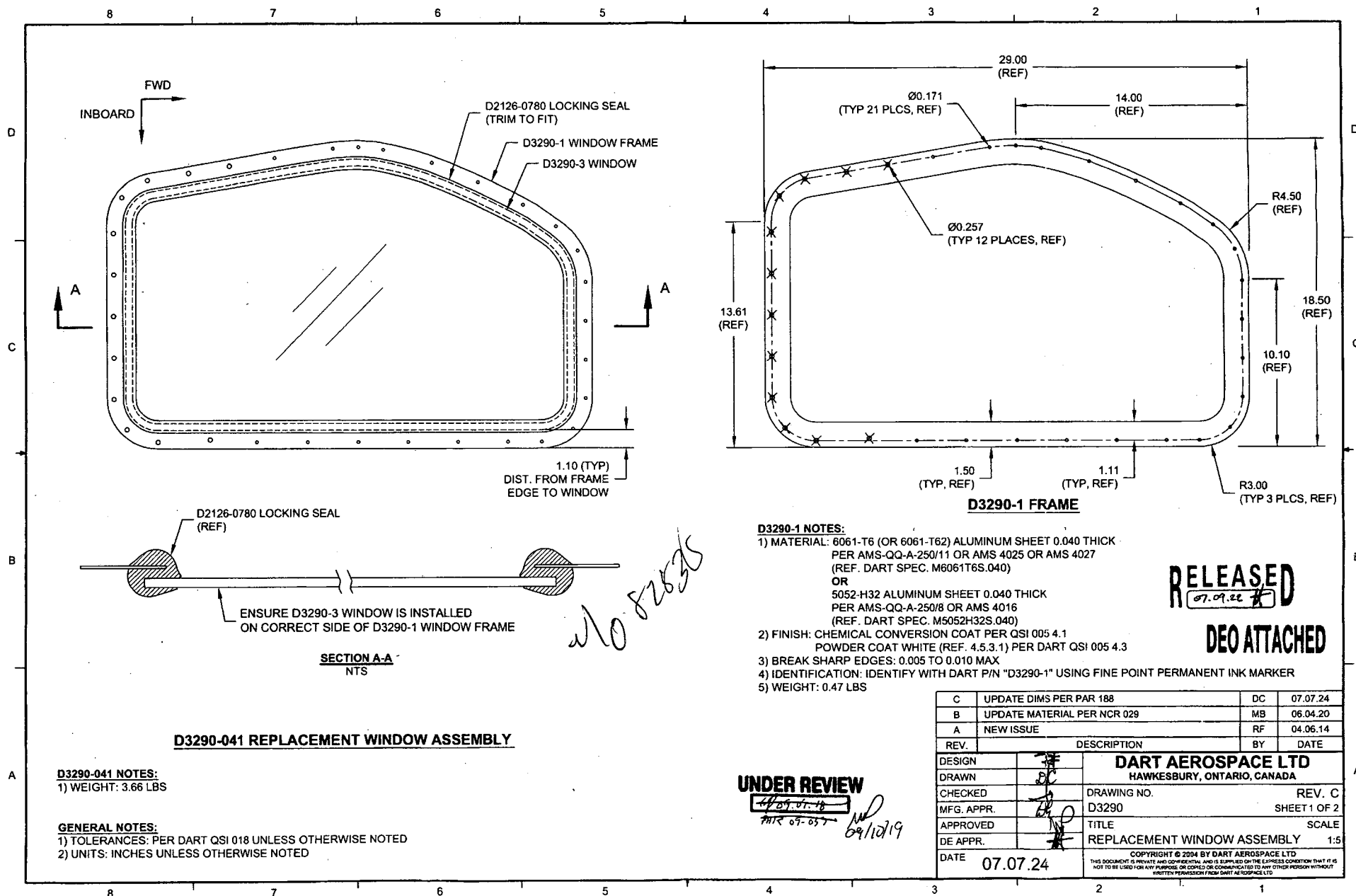
D3290-3 Window
Manufactured No

Location	Loc Qty	Loc Code
ST221	8	
75052	7	
81498	1	

D3290-041

~~B73721 x2~~
B73721 x2
B79360 x1

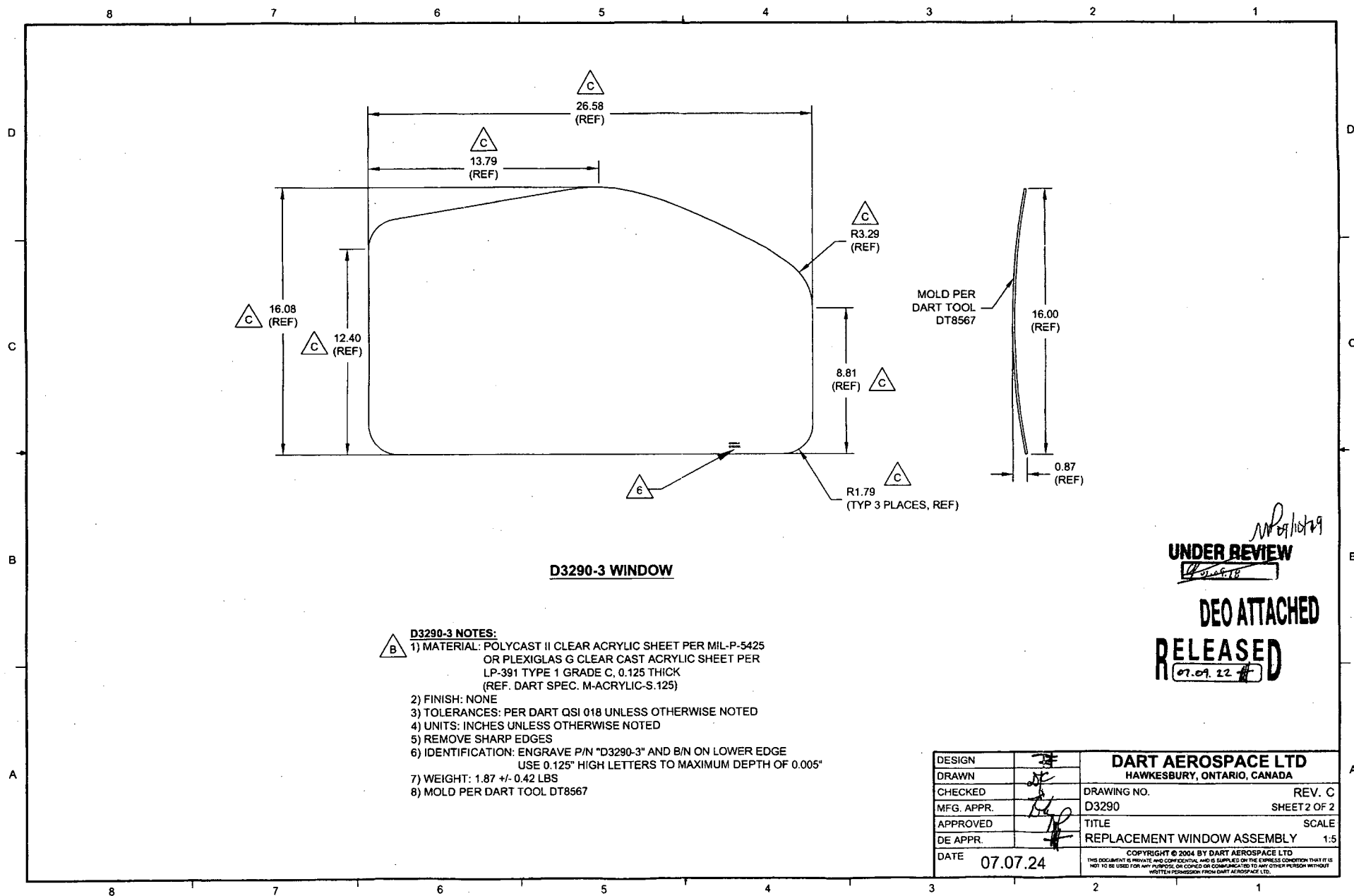
121805
SAH 12-06-13
JM 12-6-13
65
10
SAH 12-06-13
9
B83248



RELEASED
 07.07.24
 DEO ATTACHED

UNDER REVIEW

07.07.24
 07-057
 6/12/19



D3290-3 WINDOW

- D3290-3 NOTES:**
- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) REMOVE SHARP EDGES
 - 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
 - 7) WEIGHT: 1.87 +/- 0.42 LBS
 - 8) MOLD PER DART TOOL DT8567

UNDER REVIEW
W. P. 10/12/19
DEO ATTACHED
RELEASED
07.09.22

DESIGN	<i>JP</i>	DART AEROSPACE LTD	
DRAWN	<i>JP</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JP</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>JP</i>	D3290	SHEET 2 OF 2
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	REPLACEMENT WINDOW ASSEMBLY	1:5
DATE	07.07.24	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. WHO IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>q</i>	CHECKED <i>h</i>	MFG. APPR. <i>FE</i>	APPROVED <i>MD</i>		DE APPR. <i>h</i>		
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21		DATE 09/09/21		

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
 OR
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

RELEASED
 2009 -10- 09

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